

152885

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 11/2/2016 **Start Qty:** 4.00 ***4***

Required Date: 11/7/2016 **Req'd Qty:** 4.00 ***1***

Reference:

Approvals: Process Plan: 21 Date: NOV 08 2016 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run	Start	*NR1*
	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	FLOW WATER JET	0.00							
D3208	C								
100		0.00							
100	Waterjet	Memo							
FLOW CNC Waterjet	1-Cut as per Dwg D3208	0.05							
	Dwg Rev: _____								
	Prog Rev: _____								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110	QC	Memo							
Quality Control		0.01							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
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								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 152885

Tuesday, November 08, 2016 8:33:56 AM

152885

Page 2

Item ID: D3208-9 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 11/2/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 11/7/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.01				4			DAS 38 8-89 NOV 09 2016
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.05				(x4)			2016/11/10 BEB
140 *140* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.01				4			DAS 38 8-89 NOV 10 2016

DQA: _____ Date: _____



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Work Order ID 152885

Tuesday, November 08, 2016 8:33:56 AM

152885

Page 3

Item ID: D3208-9

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Doubler

Start Date: 11/2/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/7/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: Stops

0.00

150

Packaging

Memo

0.01

Packaging

4

DAS
6
9-89

NOV 11 4 2016

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.07

Quality Control

DAS
21
9-89

NOV 15 2016

DAS
21
9-89

NOV 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Misidentified ☐	Past Due ☐																								

Picklist Print

Tuesday, November 08, 2016 8:34:02 AM

Page 1

Work Order ID: 152885

152885

Parent Item: D3208-9

D3208-9

Parent Item Name: Doubler

Start Date: 11/2/2016

Required Date: 11/7/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A04.06.09New issueKJ/RF
IPP Rev:B Now on Waterjet 07-08-29 JLM Verified By:EC IPP REV
C:PER REV B 12-03-23 JLM VERIFIED BY:EC IPP REV:D
12.04.20 as per dwg rev.C DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No			100	sf	37.6000	0.1444	0.608			
M2024T3S 080												DAS	
2024-T3 .080 sheet												46	
												9-89	16/11/09

Location

Loc Qty

Loc Code

MAT021

37.6

M127668

3

M129584

10.2

M129891

10.4

M135288

14

0.69

DQA: _____ Date: _____

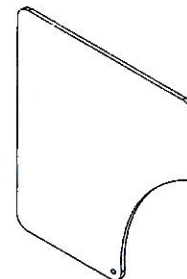
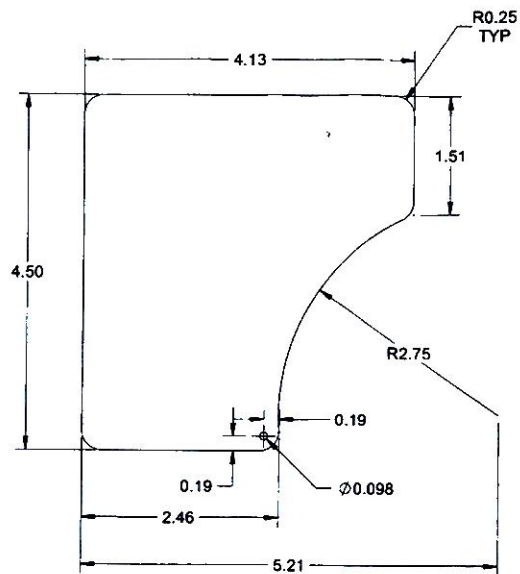


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D3208-9 DOUBLER

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.12 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3208	SHEET 8 OF 9
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	DOUBLER	NTS
DATE	12.04.12	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	